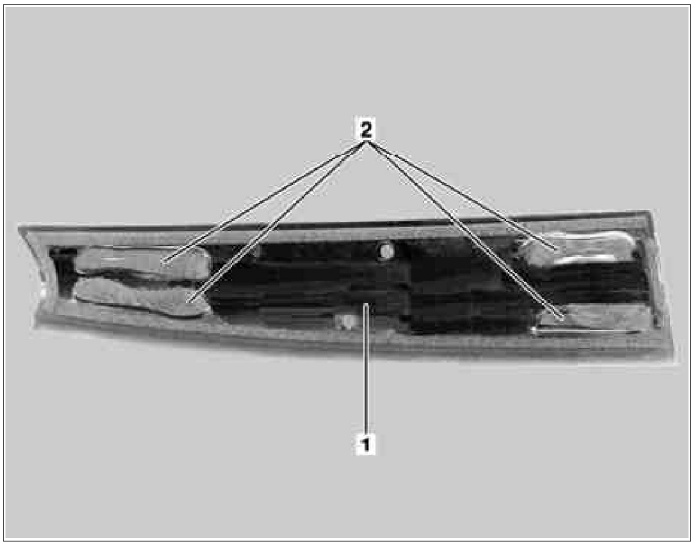
MODEL 163.113 /128 /136 /154 /157 /172 /174 /175

1 D-pillar paneling
2 Bonding material



P63.20-3336-11

	Remove		
1	Remove D-pillar paneling (1)	Separate glue bead with cutting wire. Additional pull handle for cutting wire	*WH58.30-Z-1017-02A
2	Remove any residual bonding material on the D-pillar flange	Not more than 2 mm of glue must remain.	
	Install		
3	Clean D-pillar paneling	In order to ensure a good adhesion.	
4	Apply primer to damaged paint areas on D-pillar flange	**Use 2K primer**. Allow primer to air for at least 5 minutes.	
5	Prepare D-pillar flange	If the remaining glue (cut glue bead) is older than 24 hours, also apply **primer**for paint to body to obtain optimum glued joint. If the **body** has been damaged or if there is no bonding material then apply the **primer** to the bonding first. Allow the primer to flash off for at least 10 minutes, but not for longer than 15 minutes.	*BR00.45-Z-1059-02A
6	Prepare D-pillar paneling (1)	Apply primer to bonding. Allow the primer to flash off for at least 10 minutes, but not for longer than 15 minutes.	*BR00.45-Z-1059-02A
7	Prepare glue cartridge	Betapower II (2-component electric cartridge gun) 2-component glue kit	AR67.10-P-1000-07P *WH58.30-Z-1015-20A *BR00.45-Z-1055-02A
8	Apply glue (2) as glue bead to D-pillar paneling (1)	The paneling must be put on within 5 minutes, otherwise the adhesion quality of the bonding material will be impaired. Height of adhesive bead approx. 13 mm Use reference points on inside of D-pillar paneling.	
		Betapower II (2-component electric cartridge gun)	*WH58.30-Z-1015-20A
9	Align D-pillar paneling (1)		
10	Install D-pillar paneling (1)	Firmly press D-pillar paneling to D-pillar flange.	

Commercially available tools (see Workshop Equipment Manual)

Number	Designation	Make (e. g.)	Order number
WH58.30-Z-1017-02A	Additional handle for cutting wire	Stahlwille Eduard Wille GmbH & Co.Lindenallee 27 D-42331 Wuppertal	10351/1

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WH58.30-Z-1015-20A	Betapower II (2-component electric cartridge gun)	DOW Automotive (Deutschland) GmbH Am Güterbahnhof D-35683 Dillenburg Tel.: +49 (0) 39484/8714-0	995.182

Repair products

Number	Designation	Order number
BR00.45-Z-1059-02A	Primer BETAPRIME 5404 100ml Item no. 940.870	Felt ring Tech. Großhandels GbR D-37242 Bad Sooden-Allendorf
BR00.45-Z-1055-02A	2K glue kit	168 670 00 93

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